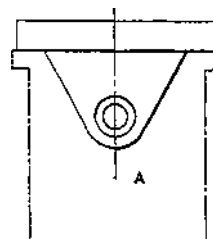


of the standards will take care of different lengths of work. Should the work differ in height, a blocking piece may be made. Sometimes special loose brackets may be more suitable for replacing the regular standards for shorter work. If there is a long distance between two bearings of the work, a third standard may be placed in between the two outside ones, if the design of the bored work permits; this may then be used for shorter work together with one of the end standards. In Fig. 2 is shown an adjustable boring jig. Here the jig consists of two parts *A* mounted on a common baseplate or large table provided with T-slots. The work *B* is located between the standards. A number of different standards suitable for different pieces of



-Tl

Jl

Fig. 3. Jig located on and supported by the Work

work may be used on the same baseplate. The jigs or

standards are held down on the baseplate by screws or bolts, and generally located by a tongue entering the upper part of the T-slots. Boring Jig supported on Work. — Boring jigs are frequently made which are located and supported on the work. Fig. 3 shows such a jig. The work *A*, which in this case represents some kind of a machine bed, has two holes bored through the walls *B* and *C*. This jig may guide the bar properly if there be but one guide bushing at *E*, but it is better if it can be arranged to carry down the jig member *D* as indicated to give support for the bar near the wall *B*. It may sometimes be more convenient to have two separate jigs located from the same surfaces on the top or sides. In other cases it may be better to have the members *D* and *E* screwed in place instead